Work Order ID 122542

Tuesday, July 22, 2014 8:39:28 AM

122542

Item ID: D3571-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Guide

Start Date: 7/21/14 **Start Qty:** 10.00 *10*

Required Date: 7/21/14 **Req'd Qty:** 10.00 *10*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLS **Date:** 14-07-23 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D3571 / Revision Nbr: Rev A									
100		0.00							
100	BAND SAW					10	Ø		MH
Bandsaw	**Memo**	0.00							14/07/25
Jeaspa Bandsaw	Cut blank 2.90 " long								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1					10	Ø		MH
HAAS 1	**Memo**	0.00							14/07/28
HAAS CNC vertical machine #1	1- Mill as per Folio FA675Rev: AA & Dwg D3571 Rev: A 2-Deburr per dwg D3571								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120						10	Ø		MH
QC	**Memo**	0.00							14/07/29
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

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Item ID: D3571-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Guide

Start Date: 7/21/14 **Start Qty:** 10.00 *10*
Required Date: 7/21/14 **Req'd Qty:** 10.00 *10*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 25 9-89
130 QC Quality Control	**Memo**	0.00				10			14-7-29
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140 HandFinish Hand Finishing	**Memo**	0.00				10	NSW4731		
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							DAS 41 9-89
150 Powdercoat Powder Coating	125028 **Memo** START TIME: 100 OVEN TEMPERATURE: 320 FINISH TIME: 130	0.00				10			14-8-11

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
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Material	☐									
Operator	☐									
Offset/Setup	☐									
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Training	☐									
Transport	☐									
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
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Item ID: D3571-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Guide
Start Date: 7/21/14 **Start Qty:** 10.00 *10*
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Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160 QC Quality Control	**Memo**	0.00				10	0	QB	14/08/12
170	Identify as per dwg & Stock Location: STO50	0.00							
170 Packaging Packaging	**Memo**	0.00				10X	DAS 28 9-89		AUG 12 2014
180	QC21- Final Inspection - Work Order Release	0.00							
180 QC Quality Control	**Memo**	0.00				MLJ 140812			

MLJ 140812

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

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Part No. _____

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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
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Process	☐									
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Training	☐									
Transport	☐									
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☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

Picklist Print

Tuesday, July 22, 2014 8:39:27 AM

Work Order ID: 122542

122542

Parent Item: D3571-1

D3571-1

Parent Item Name: Guide

Start Date: 7/21/14 **Required Date:** 7/21/14

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP Rev:A New Issue 07-02-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.500		Purchased	No			100	f	41.9470	0.241	2.536842			

M6061T6B0.750X01.500

**

6061-T6 Bar .750 X 1.50

Location	Loc Qty	Loc Code
MAT001	41.947	
129375	38.627	
m127818	1.3	
m128247	1.27	
m128866	0.75	

2.5 MH 14/07/25

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

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Part No. _____

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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
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Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
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_____

_____

_____

DART AEROSPACE LTD	Work Order:	127542
Description: Guide	Part Number:	D3571-1
Inspection Dwg: D3571 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.697	✓		MH-04	Caliper
Ø1.00 Depth 100	+/-0.010	1.001 x .103	✓			
2.75	+/-0.030	2.751	✓			
1.38	+/-0.030	1.38	✓			
1.25	+/-0.030	1.252	✓			
0.63	+/-0.010	.625	✓			
0.031 chamfer	+/-0.010	.030	✓			
Ø0.500	+0.006/-0.001	.501	✓			
Ø0.201	+0.005/-0.001	.203	✓			
R0.25	+/-0.030	.25	✓			
0.260	+0.000/-0.010	.259	✓			
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	.382 x 100°	✓			
0.125	+/-0.010	.1275	✓			
2.250	+/-0.010	2.244	✓			
0.250	+/-0.010	.254	✓			
0.188	+/-0.010	.186	✓			
0.063 chamfer	+/-0.010	.060	✓			

Measured by:	MH	Audited by:	DAS 25	Prototype Approval:	N/A
Date:	14/07/29	Date:	9-89 14-7-29	Date:	N/A

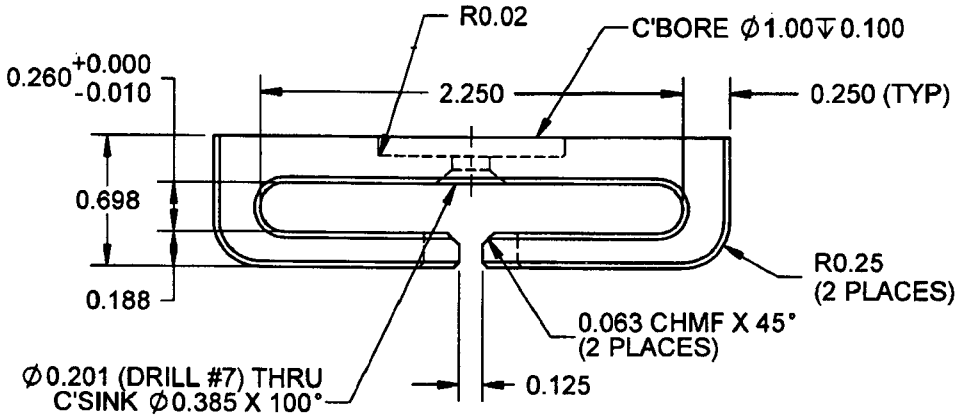
Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	

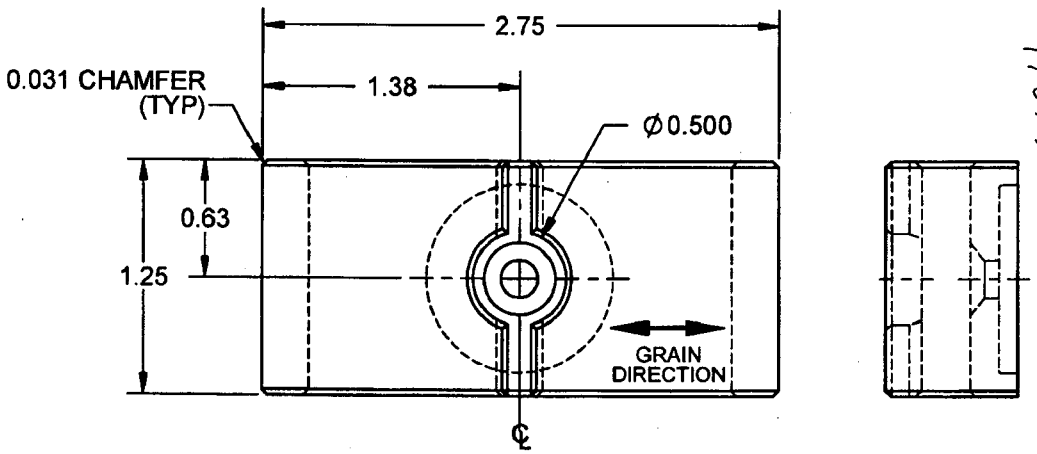
DESIGN	DRAWN BY	DART AEROSPACE LTD
LE	LE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. / REV.
PH		D3571 / REV. A
DATE		TITLE / SCALE
07.01.29		GUIDE / 1:1

SHEET 1 OF 2

REV	DATE	DESCRIPTION
A	07.01.29	NEW ISSUE

RELEASED
07.04.12





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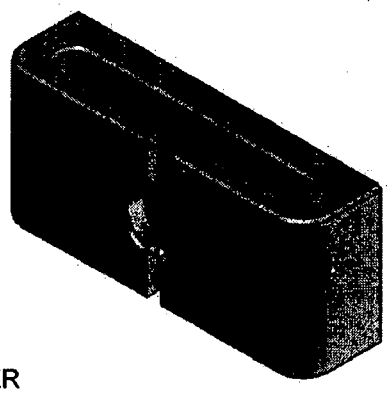
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122542 MLS
140723

D3571-1 GUIDE



NOTES:
1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) PART IS SYMMETRIC ABOUT ℄

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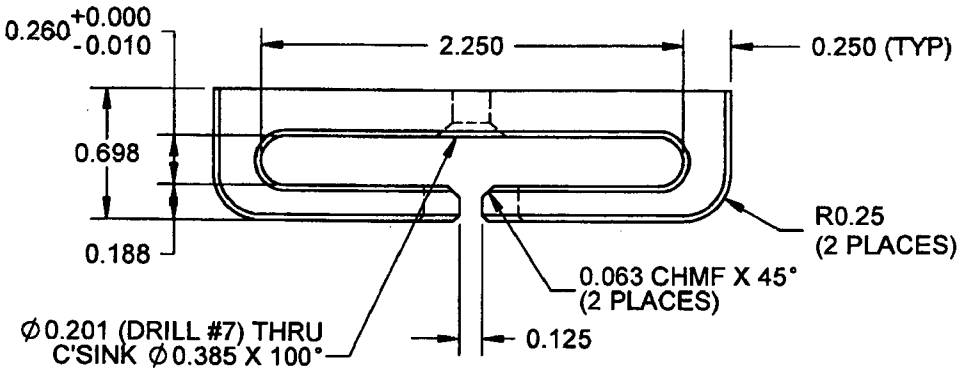
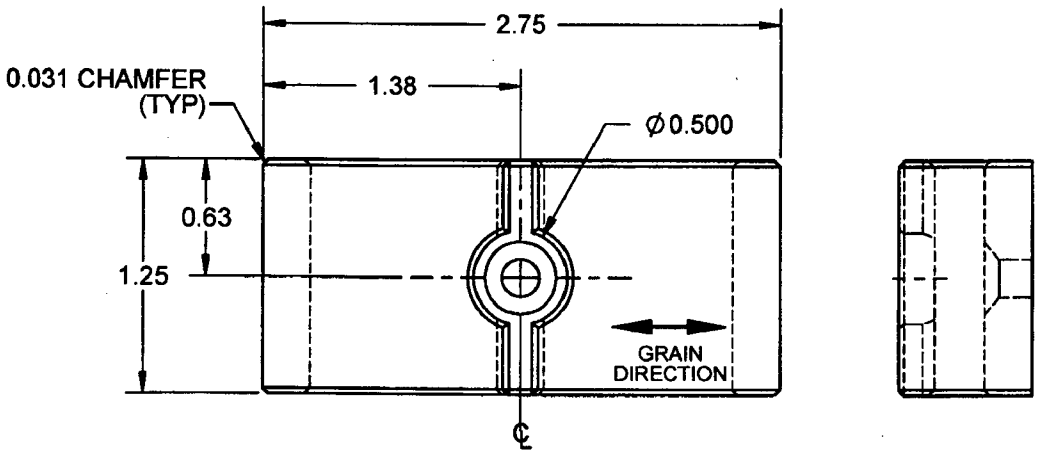
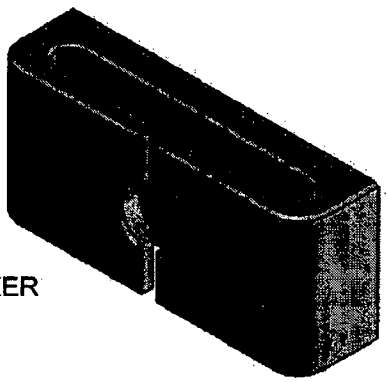
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3571	REV. A SHEET 2 OF 2
DATE 07.01.29		TITLE GUIDE	SCALE 1:1

RELEASED
07.04.12





D3571-3 GUIDE



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3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) PART IS SYMMETRIC ABOUT ℄

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